

Date: Monday, 05/01/2009 7:58:06 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LEFT ARM WELDMENT
Job Number : 44362	
Estimate Number : 12106	
P.O. Number :	Part Number : D33541
This Issue : 05/01/2009 S.O. No. :	Drawing Number : D3354 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 44249	Material :
Written By :	Due Date : 31/01/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JLO 08.01.05</u>	
Comment : est rev. A New issue EC Est Rev:B 07-12-10 rev C dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M4140HR1000	4140 round bar 1.00
-----	-------------	---------------------



Comment: Qty.: 1.0763 f(s)/Unit Total : 6.4575 f(s)
 AISI 4140 ROUND BAR
 Dia. 1.00" batch: M106565

ml 09/01/08

6

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank 12.30" long

ml 09/01/08

⑥

3.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE
 Turn as per Dwg D3354

ml 09/01/08

⑥

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1- Mill as per dwg D3354

2-Deburr as per dwg D3354

ml 09/01/08

⑥

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/01/08

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/01/2009 7:58:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 44362

Part Number: D33541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 09/01/08 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stysy R 9/01/09 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 09/01/09 (2)
MF 09-01-09

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

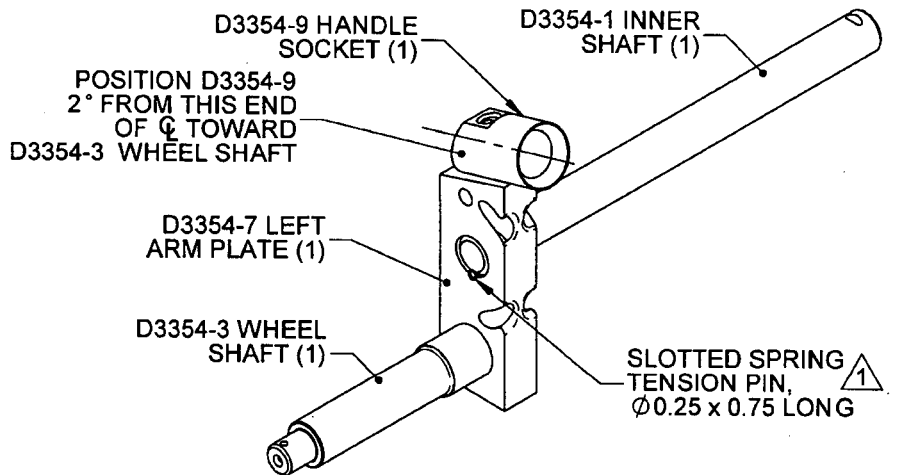
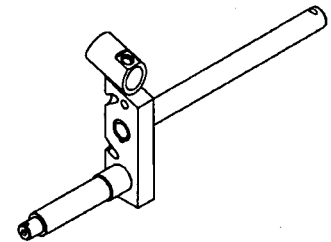
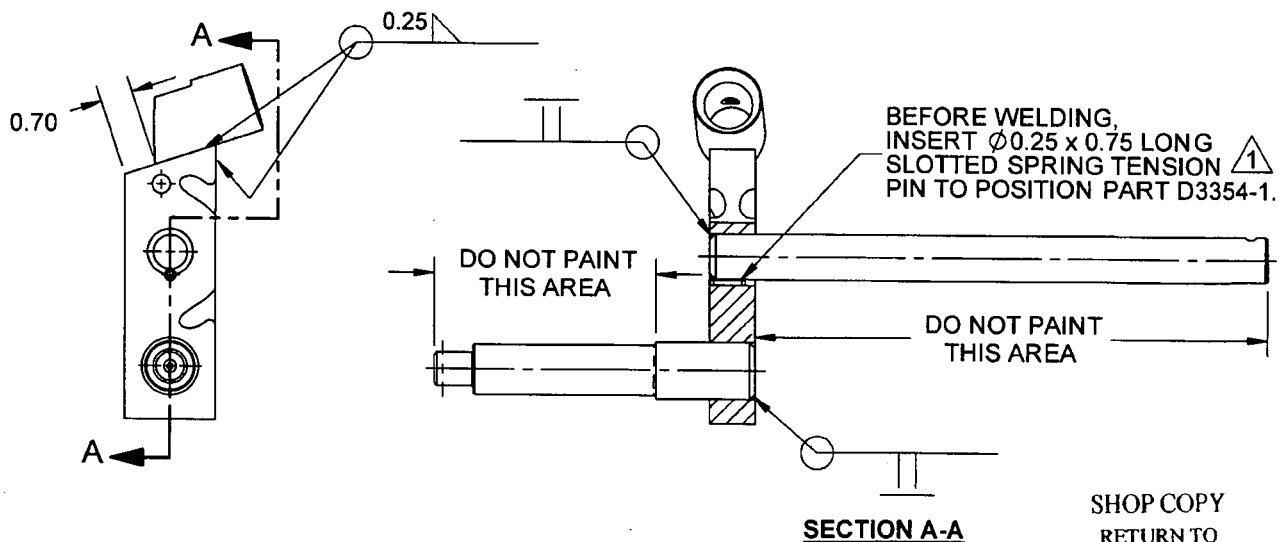
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTRELEASED
07.12.07 M/D

DESIGN <i>DF</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LB</i>	APPROVED <i>W</i>	DRAWING NO. LEFT ARM WELDMENT	REV. C SHEET 1 OF 7
DATE 07.12.06	TITLE D3354	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

**D3354-041 LEFT ARM WELDMENT****D3354-042 MIRROR ARM WELDMENT****SECTION A-A****NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

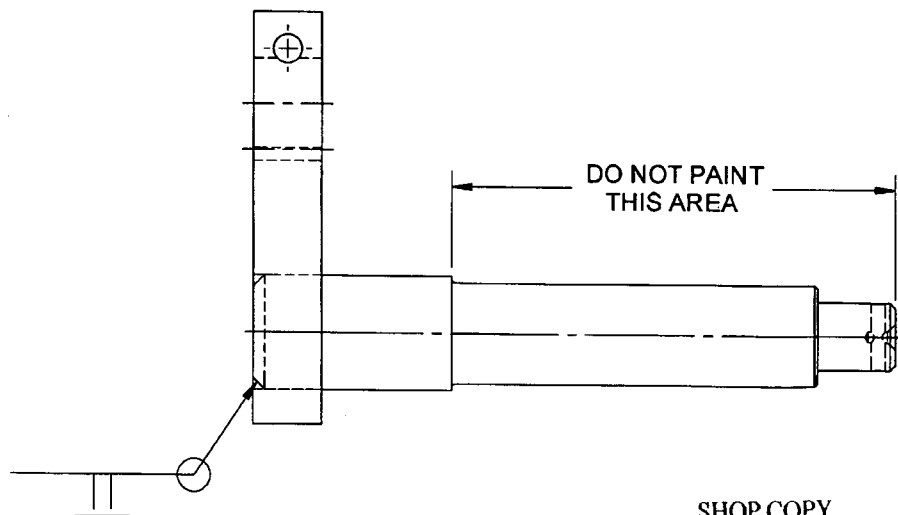
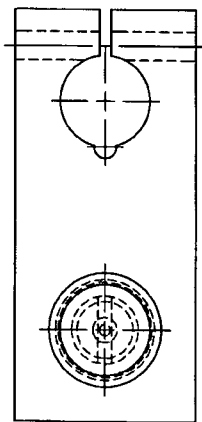
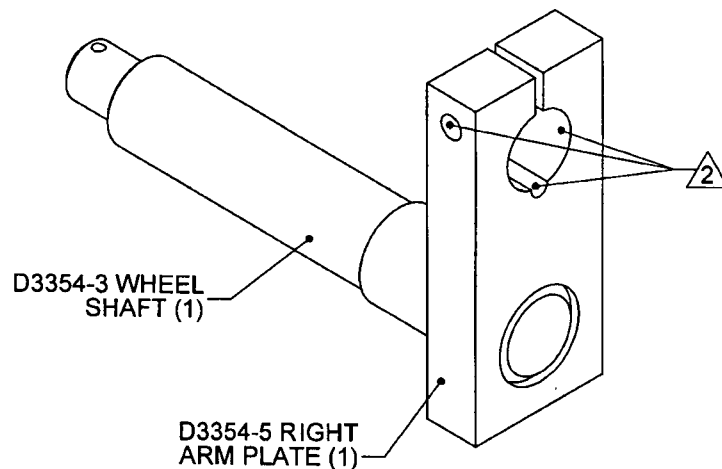
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DATE 07.12.06		TITLE LEFT ARM WELDMENT SCALE 1:2	

RELEASED
07/12/07 *W/D***D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

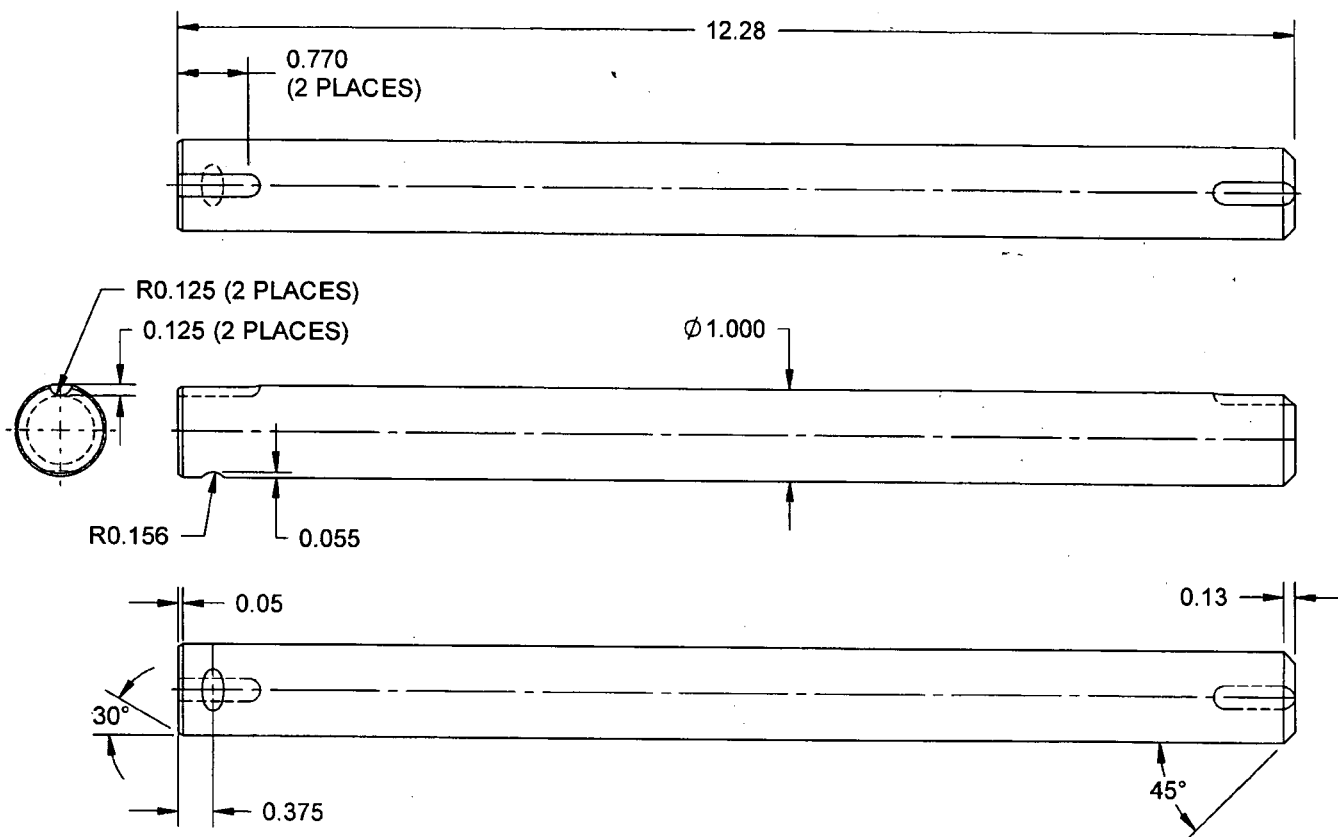
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
01/12/07 *[Signature]***D3354-1 INNER SHAFT**

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NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC / A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

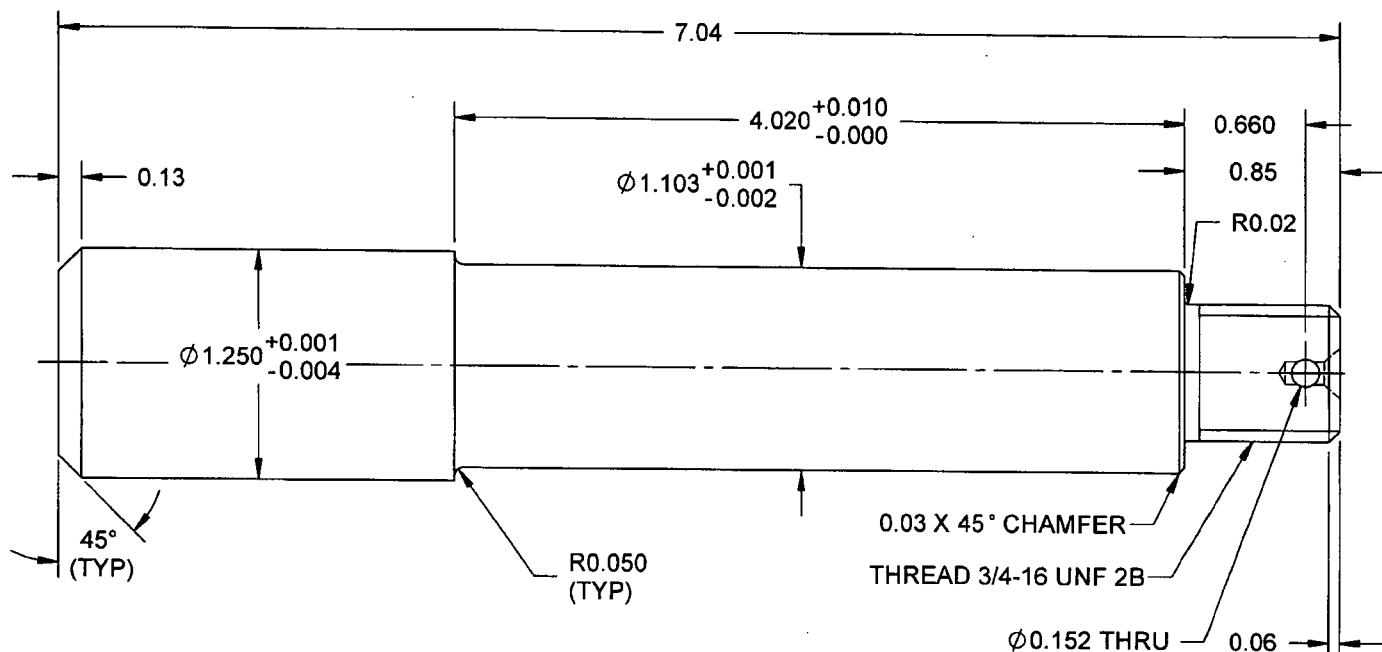
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3354	REV. C SHEET 4 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07.12.07 *[Signature]*



D3354-3 WHEEL SHAFT

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NOTES:

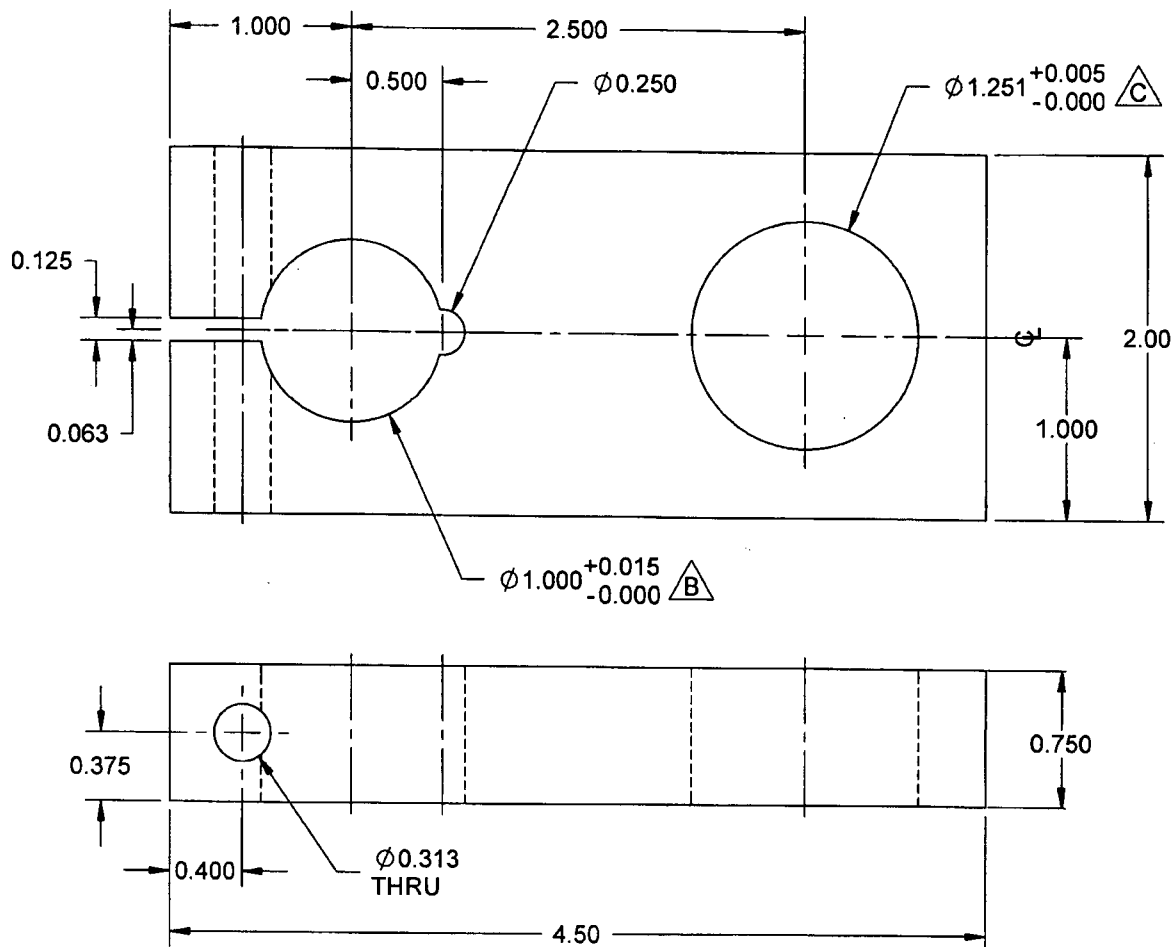
- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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CHECKED b	APPROVED MP	DRAWING NO. D3354	REV. C SHEET 5 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07/12/07 MP**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

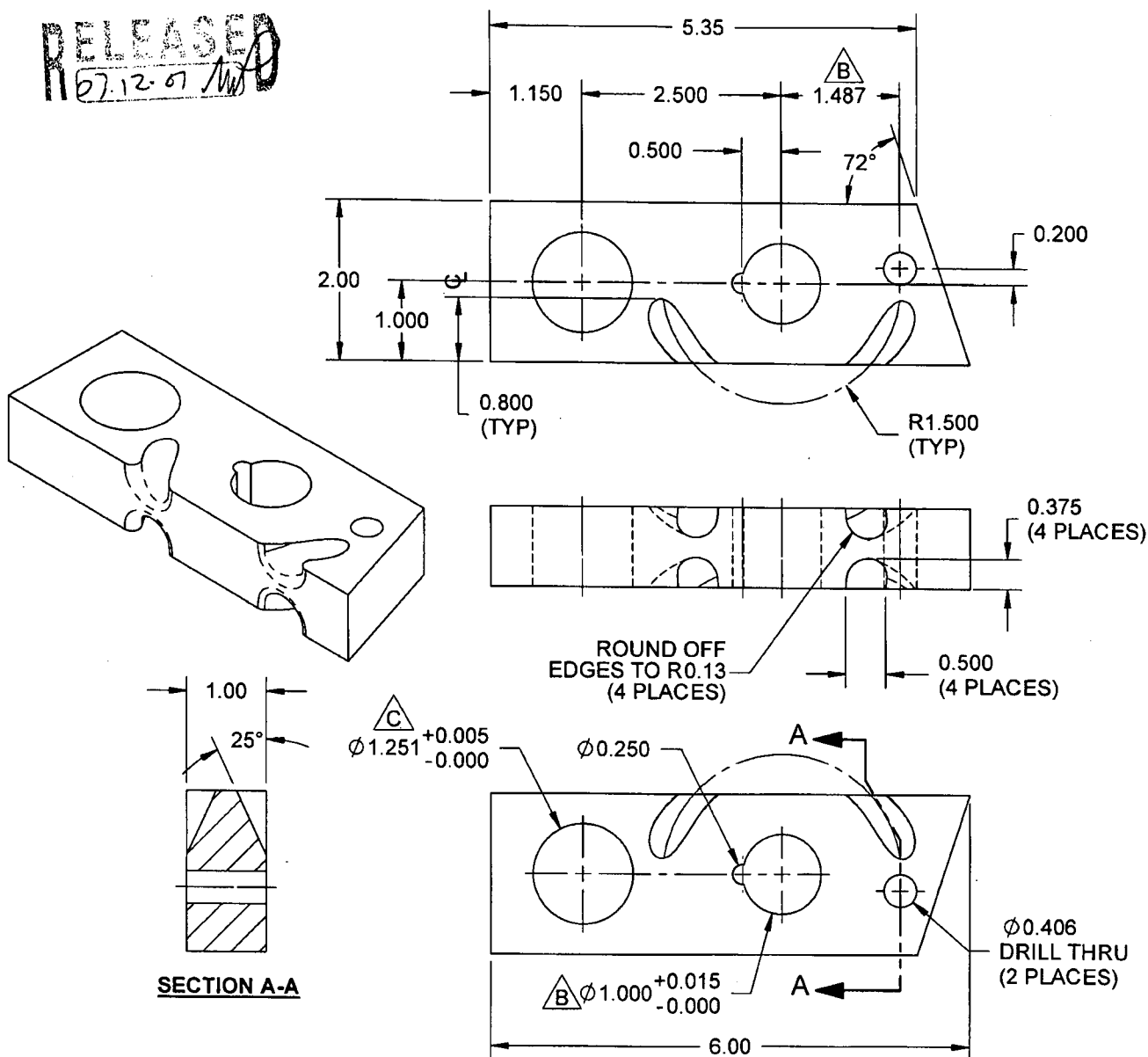
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CHECKED <i>LA</i>	APPROVED <i>MP</i>	DRAWING NO. D3354	REV. C SHEET 6 OF 7
DATE 07.12.06	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
07.12.07 *MP***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

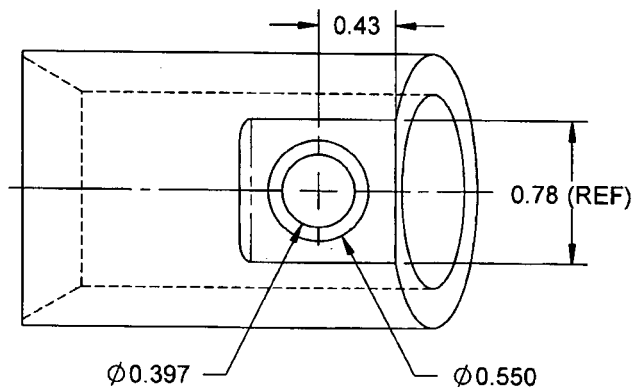
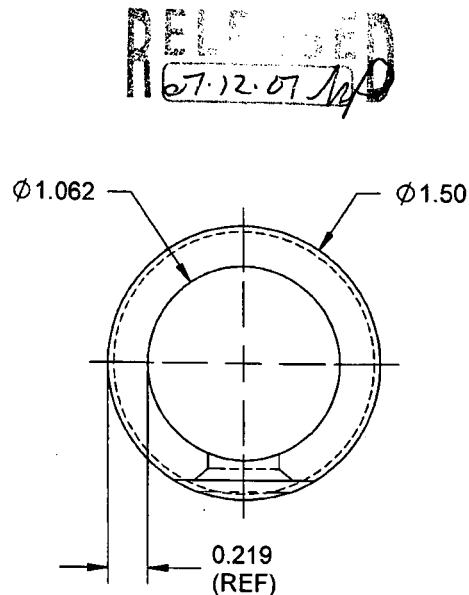
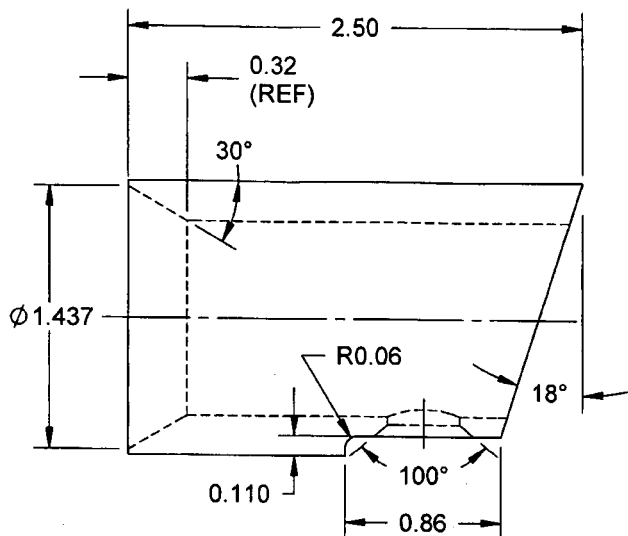
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DATE 07.12.06	TITLE LEFT ARM WELDMENT		SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAM LESS ROUND TUBING PER MIL-7-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, SUBJECT TO AMENDMENT (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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